

WHAT IS CLAIMED IS

1. An extrusion head for the production of a tubular multilayer preform of softened thermoplastic material with at least one viewing strip of translucent material extending in the extrusion direction, comprising

- an annular passage arrangement including a plurality of annular passages in mutually concentric relationship and forming mutually separate flow paths for material forming the various layers of the multilayer preform,
- at least two feed paths for feeding plasticised plastic material from at least one extruder to the annular passage arrangement,
- an annular gap nozzle having an annular gap communicating with the annular passage arrangement, and
- at least one flow passage opening into an annular passage of the annular passage arrangement for introducing material forming the viewing strip, the flow passage opening upstream of the annular gap in the region of separation of the flow paths.

2. An extrusion head as set forth in claim 1 including

- an annular storage space operatively interposed between the annular passage arrangement and the annular gap of the annular gap nozzle, the flow passage opening into said annular passage upstream of the storage space.

3. An extrusion head as set forth in claim 1 including

- a flow divider, the flow passage communicating with said annular passage by way of the flow divider.

4. An extrusion head as set forth in claim 3

- wherein the annular passage arrangement includes an outer annular passage, and
- the flow divider is arranged in the outer annular passage operably to effect complete division in the axial direction of the extrudate flowing through said outer annular passage.

5. An extrusion head as set forth in claim 1
wherein the annular passages communicate directly with the annular gap of the annular gap nozzle.

6. An extrusion head as set forth in claim 2
wherein said annular storage space is operatively disposed upstream of said annular gap and

including an annular piston in which the annular passage arrangement is provided.

7. An extrusion head as set forth in claim 1
wherein the annular passage arrangement has first, second and third annular passages comprising an inner annular passage and first and second outer passages, wherein the outer annular passages are brought together upstream of the opening of the inner annular passage into the annular gap nozzle.

8. A method of extruding a tubular multilayer preform of softened thermoplastic material with at least one strip of a different plastic material extending in the extrusion direction, wherein

in an extrusion head a plurality of layers of the thermoplastic plastic material are passed over a part of the extrusion path in mutually concentric relationship by way of mutually separate flow paths and brought together, and

the material for the strip is fed into an outer one of said layers upstream of the conjunction of the co-extruded flow portions.

9. A method as set forth in claim 8
wherein said strip of different plastic material is a viewing strip of translucent plastic material.

10. A method as set forth in claim 9

wherein an inner carrier layer and first and second outer cover layers are co-extruded, and

said strip is fed into the head such that it at least partially passes through only the cover layers.

11. A method as set forth in claim 8
wherein the preform is continuously extruded.

12. A method as set forth in claim 8
wherein the preform is discontinuously extruded.